

Date: Friday, 9/14/2007 2:00:53 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GUSSET
Job Number	: 34671C		
Estimate Number	: 10843		
P.O. Number	: N/A	Part Number	: D22495
This Issue	: 9/14/2007 S.O. No. : N/A	Drawing Number	: D2249 REV. E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: E
Previous Run	: 31609C	Material	: N/A
Written By	:	Due Date	: 10/20/2007 Qty: 20 Um: Each
Checked & Approved By	:		
Comment	: Est: D 05-02.04 Added Step 9 KJ/RF		
Additional Product			
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	M304S16GA	304/316 .063 Sheet	
Comment: Qty.: 0.0243 sf(s)/Unit Total : 0.4860 sf(s) 304/316 .063 Sheet Material: AISI 304/316 SS 0.063" thick (M304S16GA) Batch: M105130 07/09/22			
2.0	SHEAR	SHEAR	
Comment: SHEAR Cut blank: 1.000" x 1.600" SAD 07/09/22 20			
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr any rough edges SAD 07/09/22 20			
4.0	QC5	INSPECT WORK TO CURRENT STEP	
Comment: INSPECT WORK TO CURRENT STEP En 07/09/24 (20)			
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: CP 07/09/24 (20)			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 22 Date: 07/09/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/14/2007 2:00:53 PM
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Drawing Name: GUSSET

Job Number: 34671C

Part Number: D22495

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(23)

Comment: FINAL INSPECTION/W/O RELEASE

D 07/09/24

Job Completion



W 07/09-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

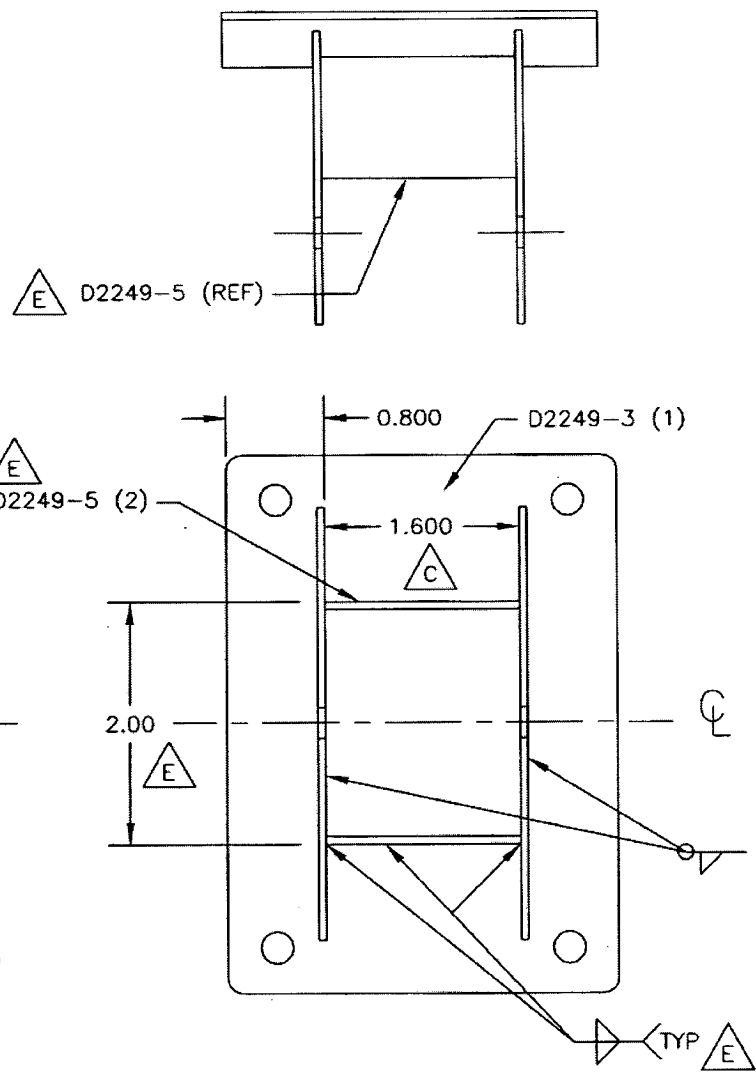
NOTE: Date & initial all entries

DART



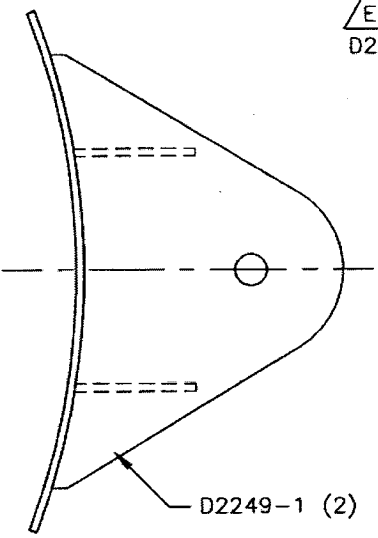
RELEASED
99.10.12 KE

DESIGN	AE	DRAWN BY	RF	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED	AE	APPROVED	[Signature]	DRAWING NO. D2249
DATE	99.09.20	TITLE	FITTING	REV. E SHEET 1 OF 4
A	94.06.20	NEW ISSUE		SCALE N/S
B	95.11.30	DIMENSION CHANGE		
C	95.12.14	DIMENSION CHANGE		
D	98.04.30	Ø0.261 WAS Ø0.257 (TSR A179) REMOVED DUPLICATE DIMENSIONS		
E	99.09.20	ADDED GUSSET		



D2249-041 ASSEMBLY

MATERIAL: AISI 304/316 SS, 0.063 THICK
WELD PER DART QSI 004
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE SPECIFIED

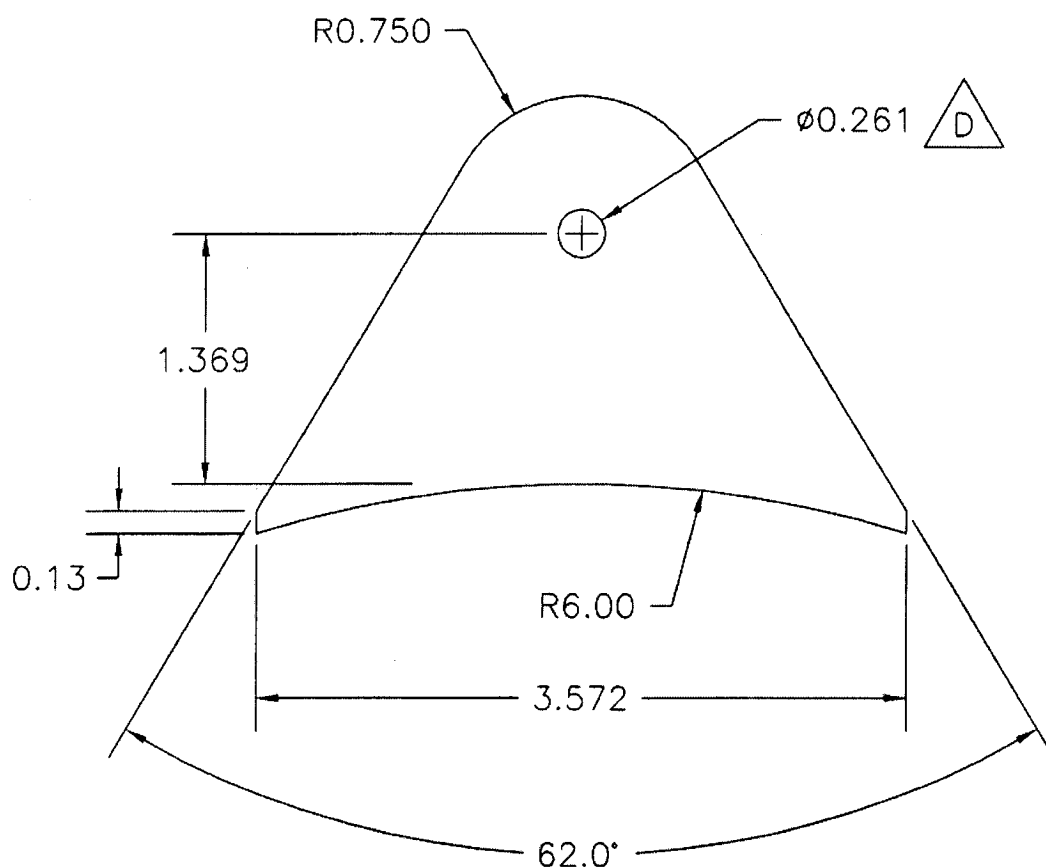


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DATE 99.09.20	TITLE FITTING		SCALE 1:1

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D2249-1 LUG

MATERIAL: AISI 304/316 SS 0.063 THICK

ALL DIMENSIONS ARE IN INCHES

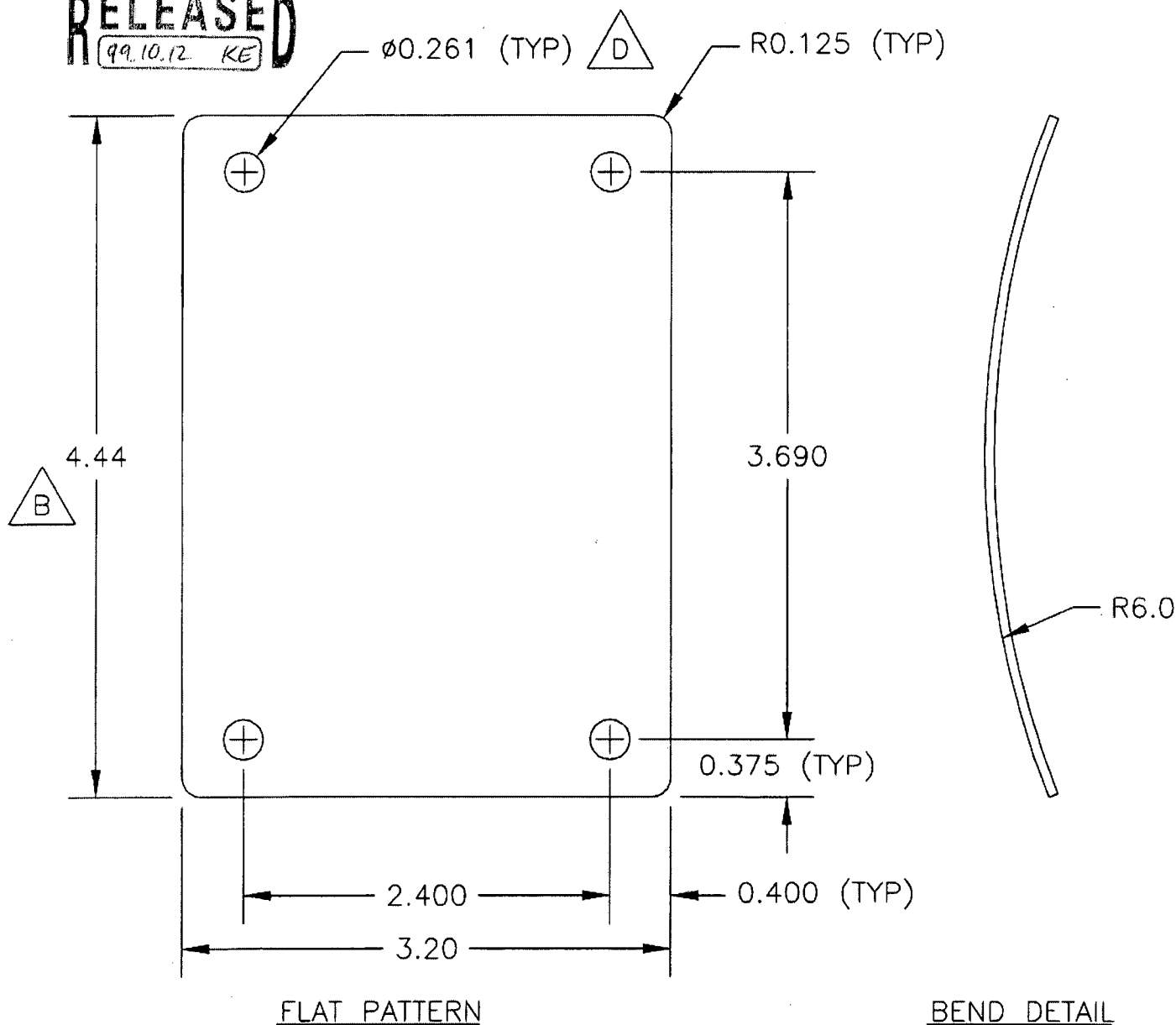
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DATE 99.09.20	TITLE FITTING		SCALE 1:1

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FLAT PATTERN

BEND DETAIL

D2249-3 BASE PLATE

MATERIAL: AISI 304/316 SS 0.063 THICK

ALL DIMENSIONS ARE IN INCHES

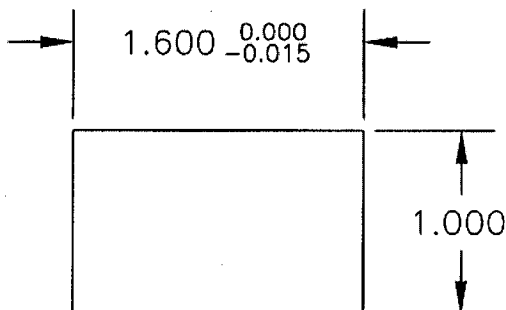
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DATE 99.09.20		TITLE FITTING	SCALE 1:1

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19.10.12 KE



D2249-5 GUSSET

MATERIAL: AISI 304/316 SS 0.063 THICK

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